

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018325**Date Inspected:** 23-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of repair weld is identified as 1G-041 of SB024-110 for SB110W. The welder is identified as 062762. ZPMC QC is identified as Mr. Peng wen jun. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-1G-Repair and WR17503.

SMAW welding of critical repair weld is identified as 2F-015 of BK004A4-014 for BK004A-014. The welder is identified as 202338. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-2F-Repair and B-CWR2264.

FCAW welding of weld is identified as 3G-007 of BK005A5-002 for BK005A-002. The welder is identified as 062808. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2333-Tc-P4-F.

ZPMC has changed joint design CJP to PJP of above mentioned weld joint BK005A5-002-007 of BK005A- 002 as per new approved WD. But they wrongly did welding on both sides of the PJP weld joint. This is informed to ZPMC QC Mr.Guo xing hui. For more information please see the attached photos.

ZPMC personnel performing Heat straightening of Bike path is identified as BK004A-014.The weld no is

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identified as BK004A2-014-016,018 is appeared to comply with HSR1 (B)-9501.

ZPMC personnel performing fit-up of bottom end diaphragm plate to bearing plate of BK004B-001 is in progress. See the attached photos.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK004A-014

BK004A8-014-029,015,016,021,022,031,032.

BK004A7-014-079,080,067,068,220,217,222,226,129,158,019,026.

BK004A5-014-036,037,016,017,022,023,042,043,039,020,021,041.

BK004A3-014-051,052,025,026.

BK004A6-014-116,031,022,115,029,030,015,019,020,013.

BK004A1-014-080,081.

BK4C-024-MEP-006.

BK5A-003-MEP-012.

BK5B-004-MEP-009.

BK8A-002-MEP-003.

BK4A-053-MEP-003.

BK4A-017-MEP-002.

BK4A-018-MEP-006.

BK4A-019-MEP-002.

BK4A-020-MEP-017.

BK4C-021-MEP-005.

BK4A-022-MEP-009.

BK4A-023-MEP-009.

BK4A-003-MEP-049,151,152.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
